



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

D3643-1
Job Sheet 171371



Part No: D3643-1

Job Qty: 8 ea

Part Name: Stiffener



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/31/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 1/31/18

Description:

Type: **SOLD**

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		1/30/18	0.00	0.00	Start Up Waterjet		18/01/31
100	Waterjet	8 pcs		1/30/18	0.00	0.56	Waterjet1		18/01/31
110	QC	8 pcs		1/30/18	0.00	0.00	QC2 Waterjet-2		18/01/31
120	QC	8 pcs		1/30/18	0.00	0.00	QC8-3		38
130	Brake NC	8 pcs		1/30/18	0.09	0.33	Brake NC 1		9-88
140	Small Fab	8 pcs		1/30/18	0.00	0.24	Small Fab-4		DAS
150	QC	8 pcs		1/30/18	0.00	0.00	QC5		38
160	HandFinish	8 pcs		1/31/18	0.00	0.44	HandFinish1		18-02-15
170	QC	8 pcs		1/31/18	0.00	0.00	QC7-2		38
180	Packaging	8 pcs		1/31/18	0.00	0.00	Packaging3-1	STO46	FEB 23 2018
190	QC21-SA	8 Ea		1/31/18	0.00	0.00	QC21		FEB 26 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	1.1800 sf (.1475 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	1 1.125	63	0

Part Specifications

Specifications could not be found.

Plex 1/31/18 11:43 AM Dart.Gagnon.Michelle

DART
AEROSPACE
S038878

Dart Aerospace Ltd.

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Stiffener

PART NO: D3643-1

Original Serial #: S038878

Revision:

Operation: Start up Operation 02/05/18

Change No:

Job No: 171371

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : 			
Misidentified	☐	Past Due	☐				

DART AEROSPACE LTD		Work Order:	171371
Description: Stiffener		Part Number:	D3643-1
Inspection Dwg: D3643 Rev: A		Page 1 of 1	

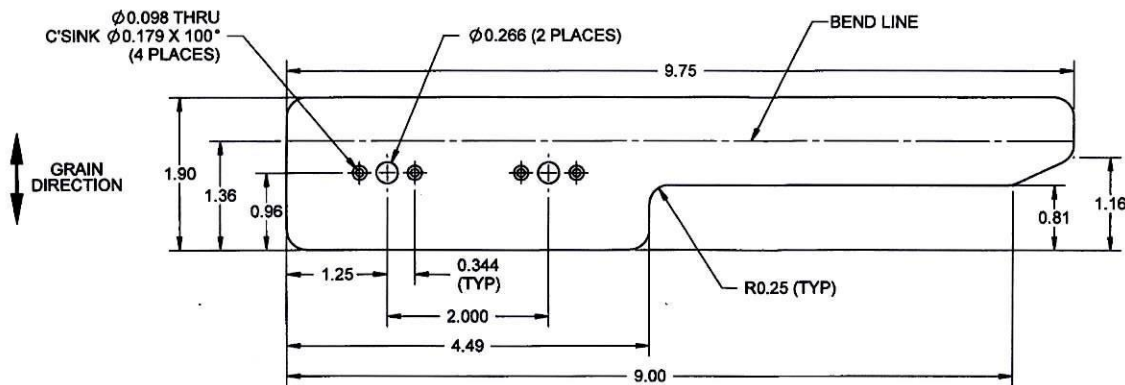
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

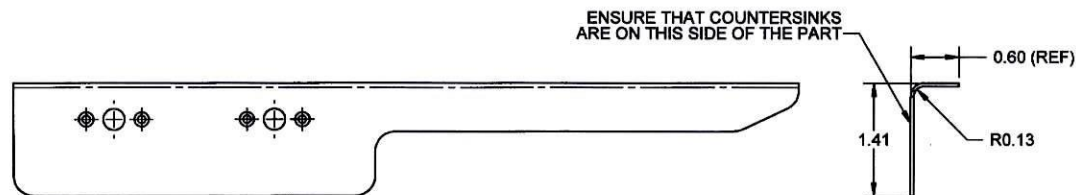
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø0.099	1		VDC-02	
Ø0.266	+0.006/-0.001	Ø0.266	1		VDC-01	
1.90	+/-0.030	1.902	1			
0.96	+/-0.030	0.954	1			
1.25	+/-0.030	1.256	1			
2.000	+/-0.010	2.006	1			
4.49	+/-0.030	4.487	1			
9.00	+/-0.030	9.003	1			
9.75	+/-0.030	9.751	1			
0.81	+/-0.030	0.812	1			
0.040	+/-0.010	0.040	1			

Measured by: SC	Audited by: 38 9-88	Prototype Approval:	N/A
Date: 18/01/31	Date: FEB 05 2018	Date:	N/A

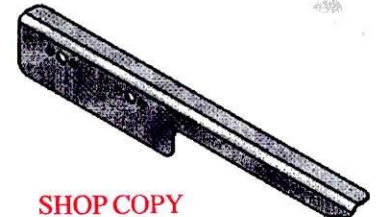
Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	AS



**D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)**



**D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)**



**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171371**

JAN 30 2018

RELEASED
07.09.07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

A	NEW ISSUE; REPLACES G10610	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DTI		
DRAWN	CE		
CHECKED	EB		
MFG. APPR.	EB		
APPROVED	EB		
DE APPR.	EB		
DATE	07.07.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 1	
DRAWING NO. D3643		TITLE STIFFENER	
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